

Work Order ID 58867

Wednesday, May 19, 2010 3:27:44 PM



Page 1

Item ID: D412-709-011

Accept



Setup Start



Revision ID:

Item Name: Escape Panel Modification

Stop



Start Date: 5/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/5/11

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D412-709

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-709-011 CHG001

8/10/06/25

P10 →

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6-25 4 (20)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/06/25

②

Dart Aerospace Ltd

W/O: 58867		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/06/05	#100	Perm. Change Part missing from w/o to part list. ADD missing part to kit D3561-1 B 56109 Qty x1 per kit (x2) (x2)	SJ	10.6.25 (10.06.28)			S 10/06/05	
10/06/05	#100	update w/o + BOM. add copy of new update BOM as reference	EC	10.06.28			S 10/06/05	

Part No: D412-709-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 5/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D412-709-011								
	Location: <u>60</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

Rev A 68

10-6-28

10/06/28

MF

10-6-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

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Work Order ID: 58867

Parent Item: D412-709-011

Parent Item Name: Escape Panel Modification

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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AN6-20A
Bolt



10-6-25 SP

Location	Loc Qty	Loc Code
----------	---------	----------

ST342	43	
110915	43	

AN960JD10L
Washer



10-6-25 SP

Location	Loc Qty	Loc Code
----------	---------	----------

ST348	4017	
110985	4017	

AN960JD616
Washer



1114988 10-6-25 SP

AN960JD616L
Washer



10-6-25 SP

Location	Loc Qty	Loc Code
----------	---------	----------

ST347	124	
111819	124	

D3118-3
Sign Assembly



10-6-25 SP

Location	Loc Qty	Loc Code
----------	---------	----------

ST037	7	
45265	2	
50365	5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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IPP rev C removed sub-components 07.11.12 EC

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3136-043 Window Assembly		Manufactured	No			120	Each	2.0000	1		10-6-25	

D3224-1 Frame		Manufactured	No			120	Each	10.0000	1		10-6-25	
------------------	--	--------------	----	--	--	-----	------	---------	---	--	---------	--

D3237-1 Seal Retainer		Manufactured	No			120	f	118.6680	8.166		10-6-25	
--------------------------	--	--------------	----	--	--	-----	---	----------	-------	--	---------	--

(D3237-1-0980) cut (1) at 98.00" as per dwg ***per kit***												
---	--	--	--	--	--	--	--	--	--	--	--	--

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Escape Panel Modification


Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3237-3		Manufactured	No			120	f	39.6680	8.166			
												
Seal Filler												

Location	Loc Qty	Loc Code
ST411	39.668	
43140	39.668	

(D3237-3-0980) cut (1) at 98.00" as per dwg ***per kit***

D3239-1 Manufactured No

120 Each 15.0000



Location	Loc Qty	Loc Code
ST046	15	
55609	15	

MS21042L3 Purchased No

120 Each 1,896.000



Nut

Location	Loc Qty	Loc Code
ST300	1896	
113537	20	
113644	376	
114523	1000	
114718	500	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L6 Nut		Purchased	No			120	Each	363.0000	3	10.6.25		

Sp

Location

Loc Qty

Loc Code

ST300

363

111578

163

114495

200

MS35207-262

Purchased

No

120

Each

24.0000

2

Sp



Screw

Location

Loc Qty

Loc Code

ST295

24

109840

24

4

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041	WINDOW ASSEMBLY
	1						D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
*2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
1				1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C

Date: 06.11.27

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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